

Abstract of the Disclosure

Buffer means 20Z consisting of an expansion conveyor 20a, inverted conveyor 20b and expansion conveyor 20c is interposed between the conveyors 24 and 25 of a conveying unit 20 so that when a trouble occurs in a receiving unit 30, the expansion conveyors 20a and 20c of the buffer means 20Z are expanded to extend the conveying line, and the extruder revolution R and the conveyor speed V are changed to reduce the conveying speed not to carry the extruded treads 1 to the receiving unit 30. When the above trouble is solved, the conveying line of the buffer means 20Z is made the shortest, and the extruder revolution R and the conveyor speed V are changed to increase the conveying speed so as to carry the buffered extruded treads to the receiving unit 30.